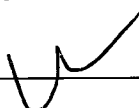
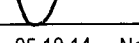


Date: Tuesday, 11/11/2008 11:28:05 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	TOW RING
<b>Job Number</b> :	43308		
<b>Estimate Number</b> :	10793		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3407043
<b>This Issue</b> :	11/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3407 REV E
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	43000	<b>Drawing Revision</b> :	E
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	18/11/2008
<b>Comment</b> :	Est Rev:A 05.10.14 New issue KJ/EC Est Rev:B 08-09-09 revE as per dwg DD verified by:EC		

Qty: 12 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34073	Stem
-----	--------	------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3407-3 Stem B43021

EL 8-11-12 All x16

2.0	D34075	Ring
-----	--------	------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3407-5 Ring B42246

EL 8-11-12 x16

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 &amp; QSI 004

A/R TIG174 ROD Batch: M106115

EL 8-11-12 x16

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



**Comment:** VISUAL WELDING INSPECTION

108/11/13 (16)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

108-11-13 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/11/2008 11:28:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 43308

Part Number: D3407043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M109152



(16x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

\*\*Mask Threaded Section\*\*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00  
400 OF  
1:30

M-L 08/11/19

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-19

(16x)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST464

SS 08/11/20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

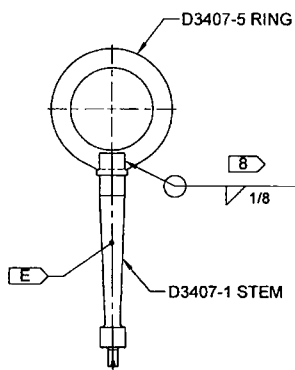
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

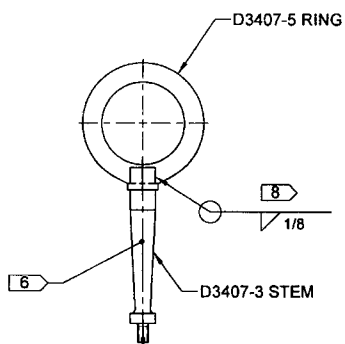
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

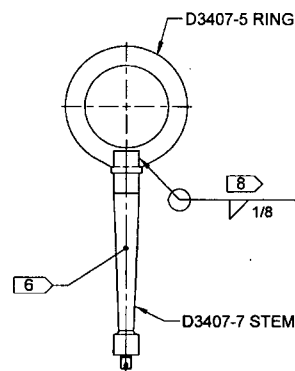
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



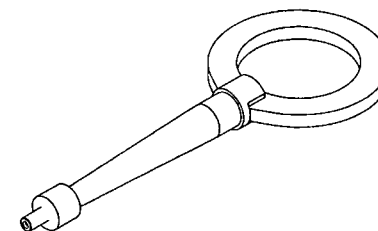
**D3407-041 TOW RING**



**D3407-043 TOW RING**



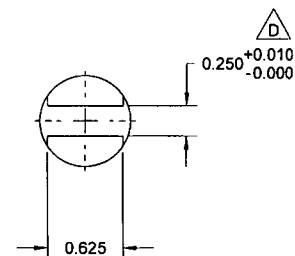
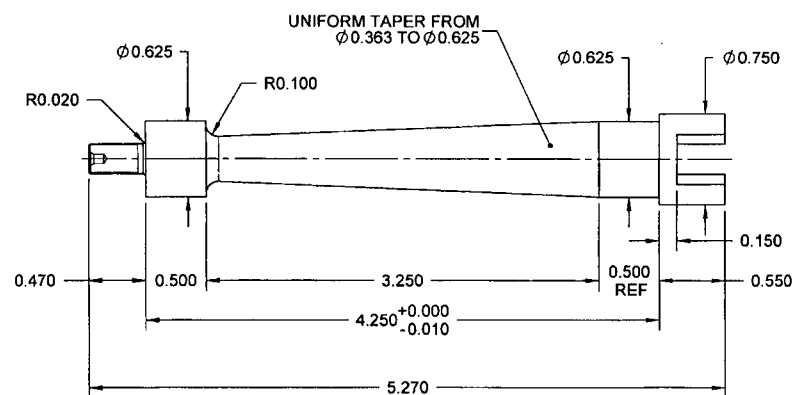
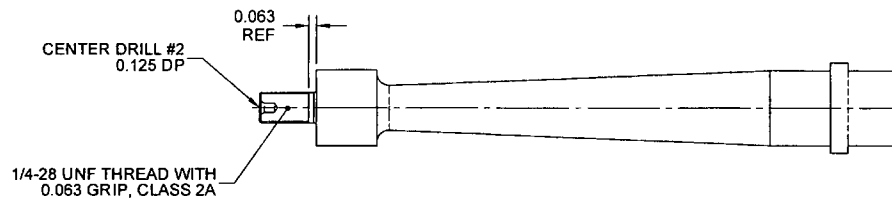
**D3407-045 TOW RING**



**RELEASED**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
  - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B8-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DRAWN	CHECKED	MFG. APPR.
APPROVED	DATE	08.07.23	
<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D3407</b> TITLE <b>TOW RING</b> REV. <b>E</b> SHEET <b>1 OF 5</b> SCALE <b>NTS</b> <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



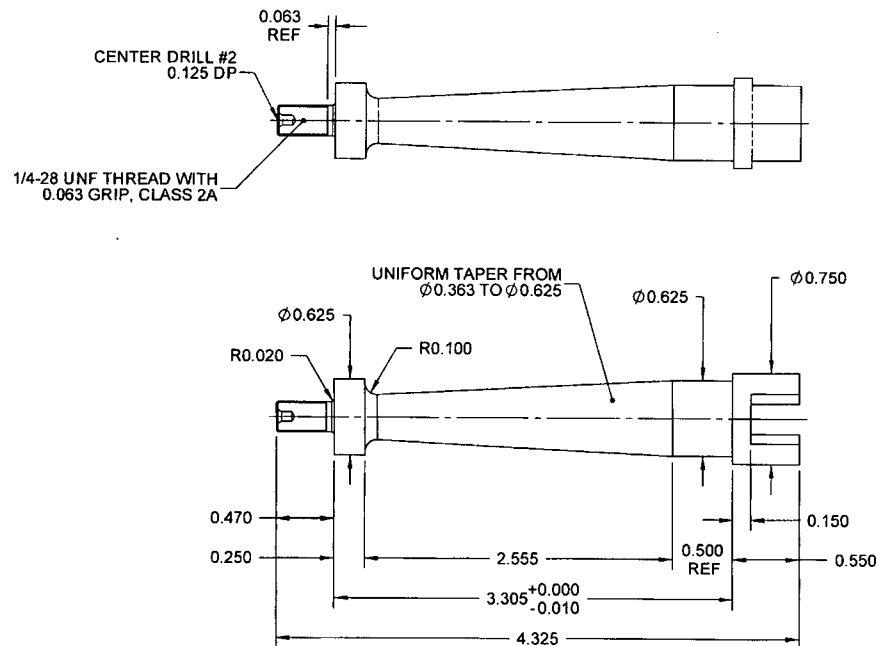
**D3407-1 STEM**

**NOTES:**

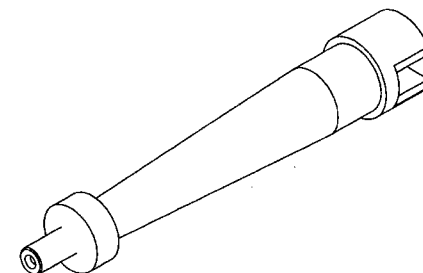
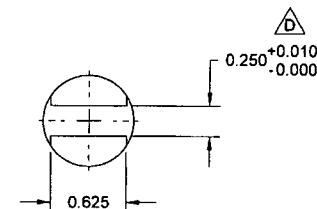
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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
**D3407-3 STEM**

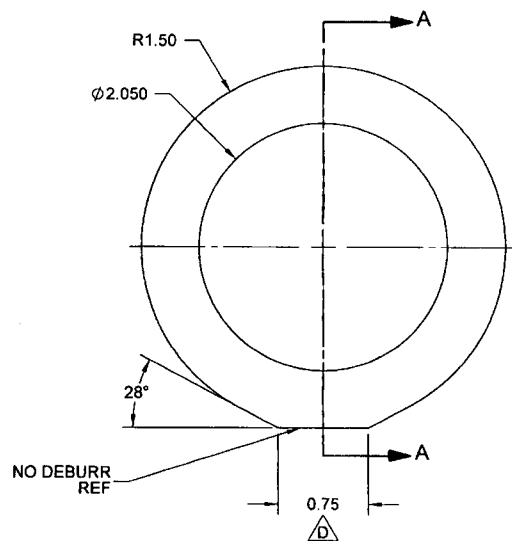


- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

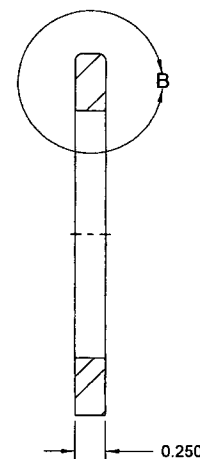
*Wb 43308*

**RELEASED**  
08-08-01

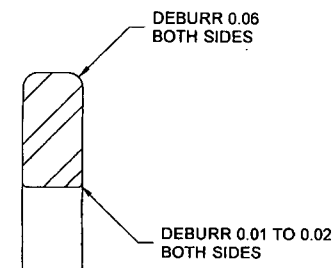
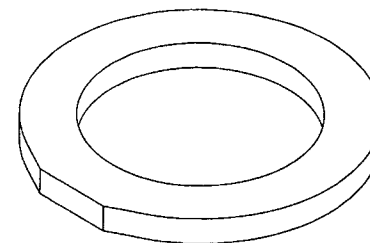
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MFG. APPR.		D3407	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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**D3407-5 RING**



**SECTION A-A**



**DETAIL B  
SCALE 2X**

**RELEASED**  
08-07-23

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

*W643308*

DESIGN	90	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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8 7 6 5 4 3 2 1

D

D

C

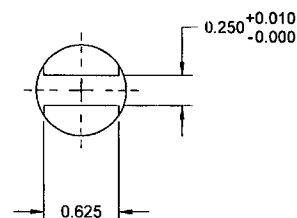
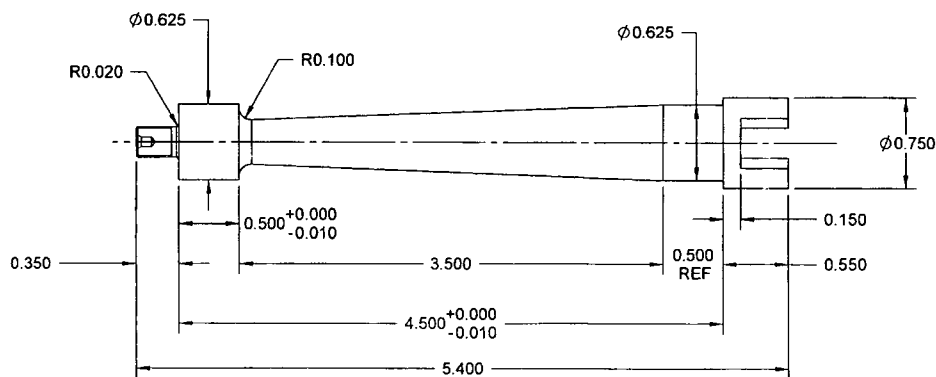
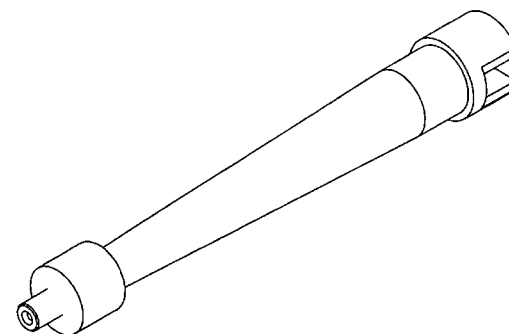
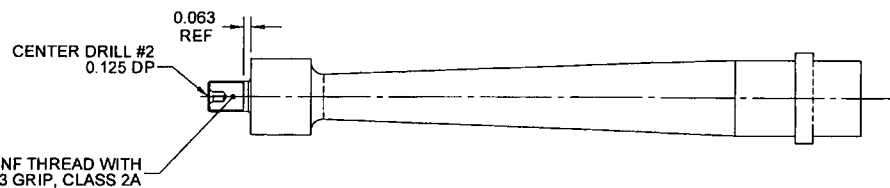
C

B

B

A

A






**D3407-7 STEM**

*W043308*

**RELEASED**

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JPM	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1